

Date: Wednesday, 6/28/2006 4:17:26 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 27738		
Estimate Number	: 10308		
P.O. Number	: N/A	Part Number	: D26173
This Issue	: 6/28/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2617 REV D2
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24400	Drawing Revision	: D2
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 7/22/2006
Checked & Approved By	: <u>06/06/09</u>	Qty:	20
Comment	: Est G 04.07.14 Reformat; added step 5KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W
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Comment: Qty.: 0.0765 f(s)/Unit Total: 1.5309 f(s)

6061-T6 Round Bar 1.5"

Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.375" tubing x 0.058" wall

(M6061T6T0.375W.058) Batch: M19051

06/07/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE

Turn as per Folio FA437 and Dwg D2617

N/A Machined Manually
06/07/19 22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/19 22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06/07/19 x 22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

06/07/19 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 9 Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: BUSHING

Job Number: 27738

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/20 (22)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 07.21 (22)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5153

AB 06/07/21 (22)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/24 (22)

Job Completion



HJ 06.07.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

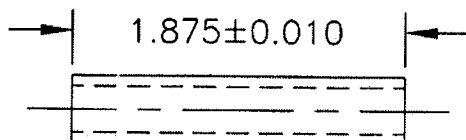
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

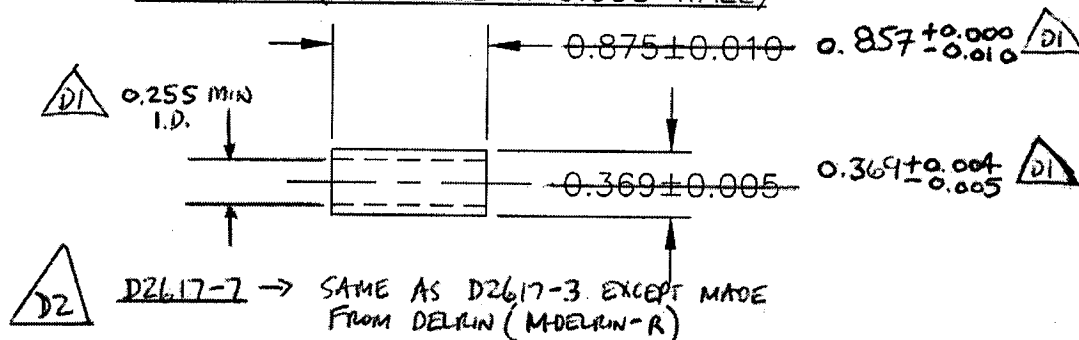


DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
A	96.10.08		NEW ISSUE		
B	97.05.08		.875 WAS 1.125		
C	97.06.04		0.369 DIA WAS 0.375		
D	01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	CP-#	04.07.12	CORRECT TOLERANCE (NCR 779)		

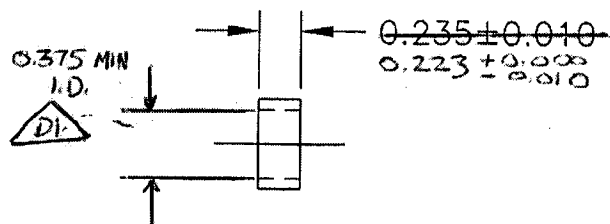
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27738

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